

Date: Thursday, 12/20/2007 3:17:14 PM
 User: Kim Johnston

Process Sheet

3

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET
Job Number : 36466A01	
Estimate Number : 10143	
P.O. Number : <i>N/A</i>	Part Number : D20135
This Issue : 12/20/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2013 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : C
Previous Run : 29088	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 1/15/2008
Checked & Approved By : <i>[Signature]</i>	Qty: 5 Um: Each
Comment : Est Rev:A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.8165 f(s)/Unit Total : 9.0825 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: *1106132*

FF 10-01-08

5

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch as per template D2013-T5 and Dwg D2013

FF 10-01-08

5

2-Flatten ends of D2013-5 tube as per Dwg D2013 using DT8545

FF 10-01-08

5

3-Bend (1) tube as per Dwg D2013 using Jig DT8201 Identify as D2013-5.

FF 11-01-08

5

4-Deburr as required

FF 10-01-08

5

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

C 08/01/14

4.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

D 08/01/14

Job Completion



U 28-01-14

Pkg
 L7 ID + spec

C 208/01/14 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

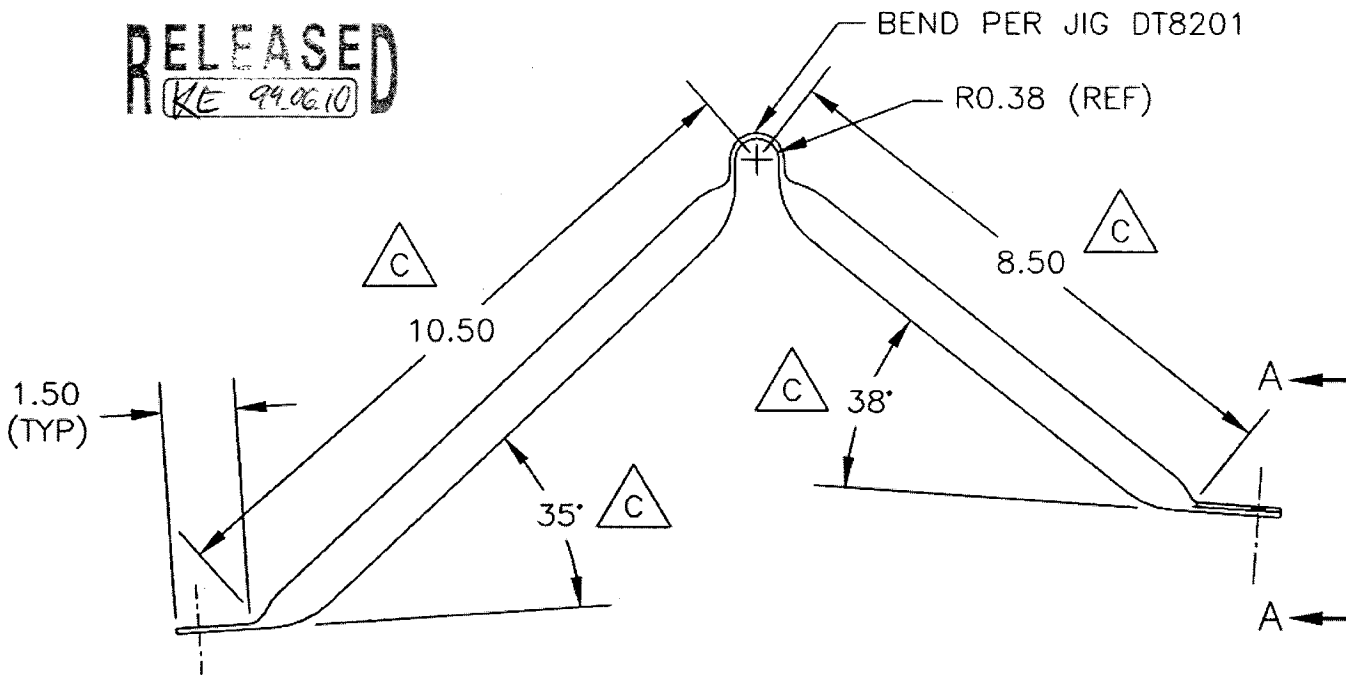
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 08/01/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

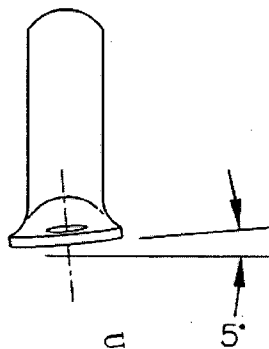
NOTE: Date & initial all entries

RELEASED
KE 94.06.10

DART



D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)



DRILL $\varnothing 0.257$ (TYP)
0.400 (TYP)

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
JB	RF		
CHECKED AE	APPROVED JD	DRAWING NO. D2013	SHEET 1 OF 3
DATE 99.06.07		TITLE MIRROR BRACKET	SCALE NFS
A	90.10.22	NEW ISSUE	
B	94.06.15	REDRAWN	
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS	

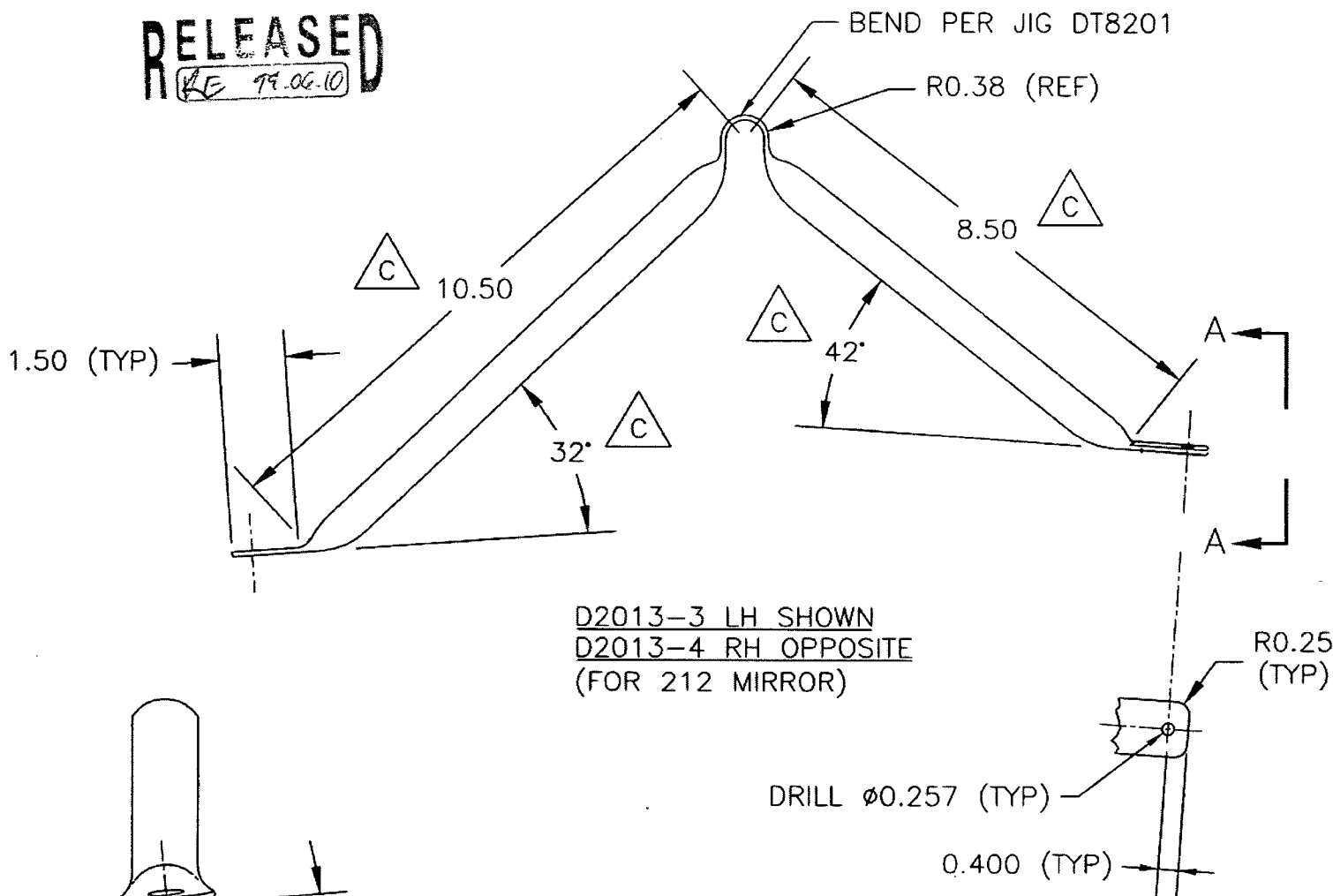
VIEW A-A
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36466A01

RELEASED
KE 79.06.10

DART



DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	[Signature]	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 2 OF 3
		SCALE	NTS	



D2013-3 LH SHOWN
D2013-4 RH OPPOSITE
(FOR 212 MIRROR)

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

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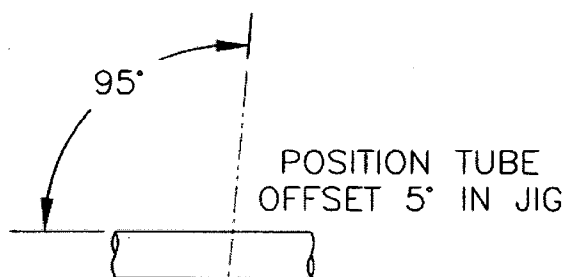
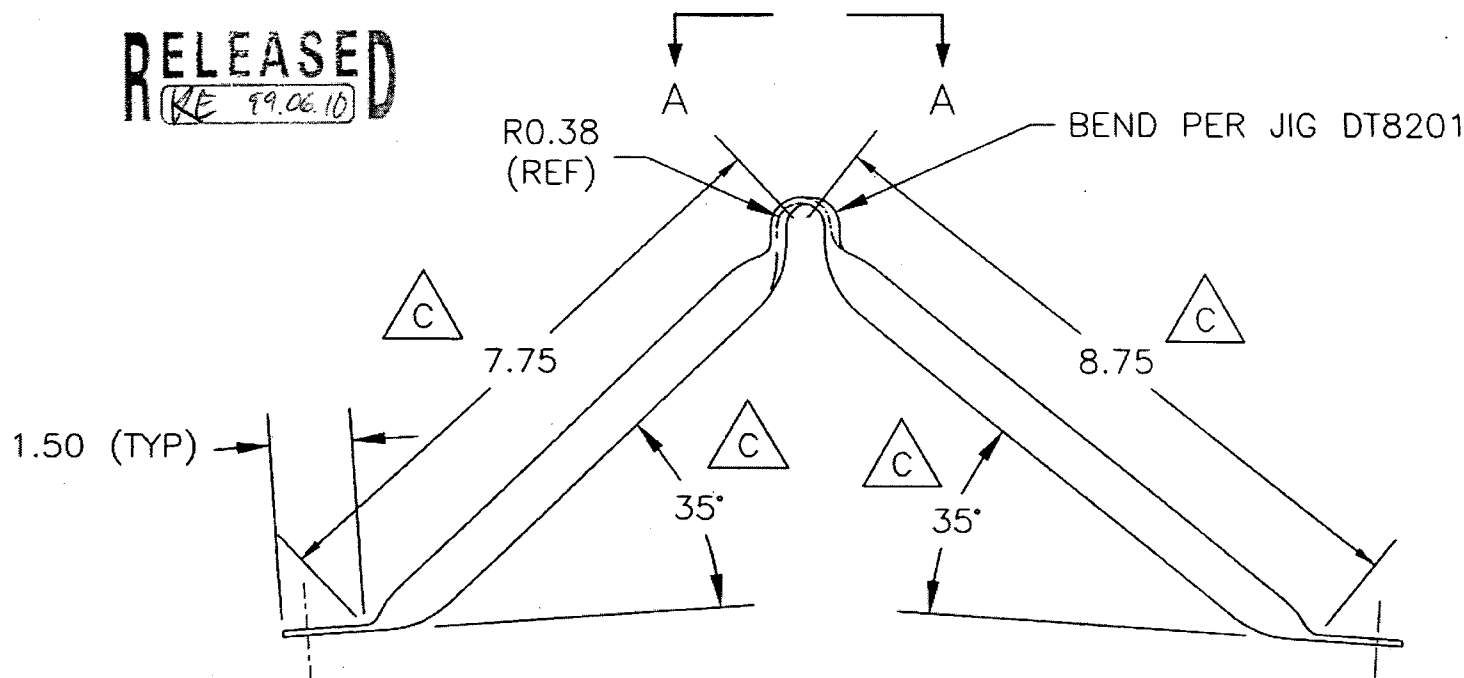
WORK ORDER
36466A01

RELEASED
(KE 99.06.10)

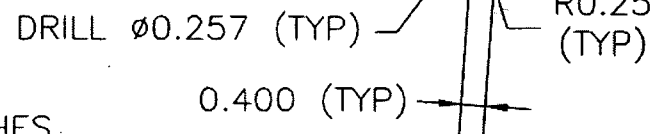
DART

REPRODUCED

DESIGN	JB	DRAWN BY	RM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 3 OF 3
				SCALE NTS



D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)



CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

WORK ORDER
NR 36466A 01
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BEND LINE